

Split

C420A.

Work Order ID 79036-1

\*79036\*

Page 1

January-18-12 3:52:59 PM

Item ID: D3393-041

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Battery Lock Assembly

Start Date: 18/01/2012 Start Qty: 10.00

\*10\*

Cust Item ID:

Required Date: 01/02/2012 Req'd Qty: 10.00

\*10\*

Customer:

Reference:

Approvals: Process Plan: M.C.J.

Date: 12/01/18

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3393

Rev A

100

0.00

\*100\*

Small Fab

Small Fab

Memo

0.00

Small Fab

1-Open D3373-1 lock package. Keep keys, lock body, lock body nut, flat cam and lock barrel. Discard the rest. 2-Using the flat cam, fabricate D3369-5 as per Dwg D3369 Identify as D3369-53-Assemble D3393-041 as per Dwg D3393. Insert lock body and fasten

② TF 12-02-29

110

0.00

\*110\*

Large Fab

Large Fab

Memo

0.00

Large Fab

Tack Weld lock shaft to flat cam of a Max 1/8" Long QtyPart Number  
Description Batch A/RN/A SS Rod M114507

EL 12-2-29 (X2)

120

0.00

\*120\*

QC

Quality Control

QC9- Inspect visual per QS1004- Fusion Welds

Memo

0.00

Plc 12.02.29 2X Ø

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

**\*790.36\***

January-18-12 3:52:59 PM

\*N900040100\*

Setup Start \*NS1\*

Stop \*NS2\*

Cust Item ID:

\*10\*

\*10\*

**Customer:**

Run Start \*NR1\*

Stop \*NR2\*

Date:

Insp.  
Stamp

0.00

0.00

## Memo

Apply Crazy Glue to cap and press into Body 9567K21  
Batch: 17120590

0.00

QC5- Inspect part completeness to step on W/O

## Memo

0.00

0.00

Identify as per dwg & Stock Location: SL 4-12

## Memo

### Packaging

W/O:		WORK ORDER CHANGES					
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# Work Order ID 79036

\*79036\*

Page 3

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\*10\*

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

160

QC21- Final Inspection - Work Order Release

0.00

\*160\*

QC

Memo

0.00

Quality Control

MLJ 12/03/02

12-03-2  
#8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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# Picklist Print

January-18-12 3:53:03 PM

Page 1

Work Order ID: 79036

\*79036\*

Parent Item: D3393-041

\*D3393-041\*

Parent Item Name: Battery Lock Assembly

Start Date: 18/01/2012

Required Date: 01/02/2012

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:A New Issue 05-11-22 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

5/16WC		Purchased	No			100	Each	3,590.000	2	20			
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\*5/16WC\*

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SS Flat Washer 5/16 FW516S1

(2) FF 12-02-29

Location	Loc Qty	Loc Code
----------	---------	----------

ST377	3290	
-------	------	--

119343	590	
--------	-----	--

120262	2700	
--------	------	--

ST522	300	
-------	-----	--

120208	300	
--------	-----	--

9567K21		Purchased	No			100	Each	27.0000	2	20			
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\*9567K21\*

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Polyethelene Cap

(2) FF 12-02-29

Location	Loc Qty	Loc Code
----------	---------	----------

ST380	27	
-------	----	--

110822	27	
--------	----	--

D2728-7		Manufactured	No			100	Each	0.0000	0	0			
---------	--	--------------	----	--	--	-----	------	--------	---	---	--	--	--

\*D2728-7\*

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Dart Logo label

22554 (2)

(2) FF 12-02-29

D3373-1		Manufactured	No			100	Each	69.0000	1	10			
---------	--	--------------	----	--	--	-----	------	---------	---	----	--	--	--

\*D3373-1\*

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Cam Lock

2 (2) FF 12-02-29

Location	Loc Qty	Loc Code
----------	---------	----------

ST039	69	
-------	----	--

58463	2	
-------	---	--

74862	19	
-------	----	--

75666	48	
-------	----	--

2

W/O:		WORK ORDER CHANGES					
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# Picklist Print

January-18-12 3:53:03 PM

Work Order ID: 79036

\*79036\*

Parent Item: D3393-041

\*D3393-041\*

Parent Item Name: Battery Lock Assembly

Start Date: 18/01/2012

Required Date: 01/02/2012

Start Qty: 10.00

Required Qty: 10.00

D3393-1

Manufactured No

\*D3393-1\*

Battery Lock Casing

79171

100

Each

3.0000

1

10

\*\*

2 FF 12/02/29

Location

Loc Qty

Loc Code

st493

3

62953

3

D3393-3

Manufactured No

\*D3393-3\*

Cam Lock Shaft

140

Each

0.0000

1

10

\*\*

2 FF 12-02-29

B77090A

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

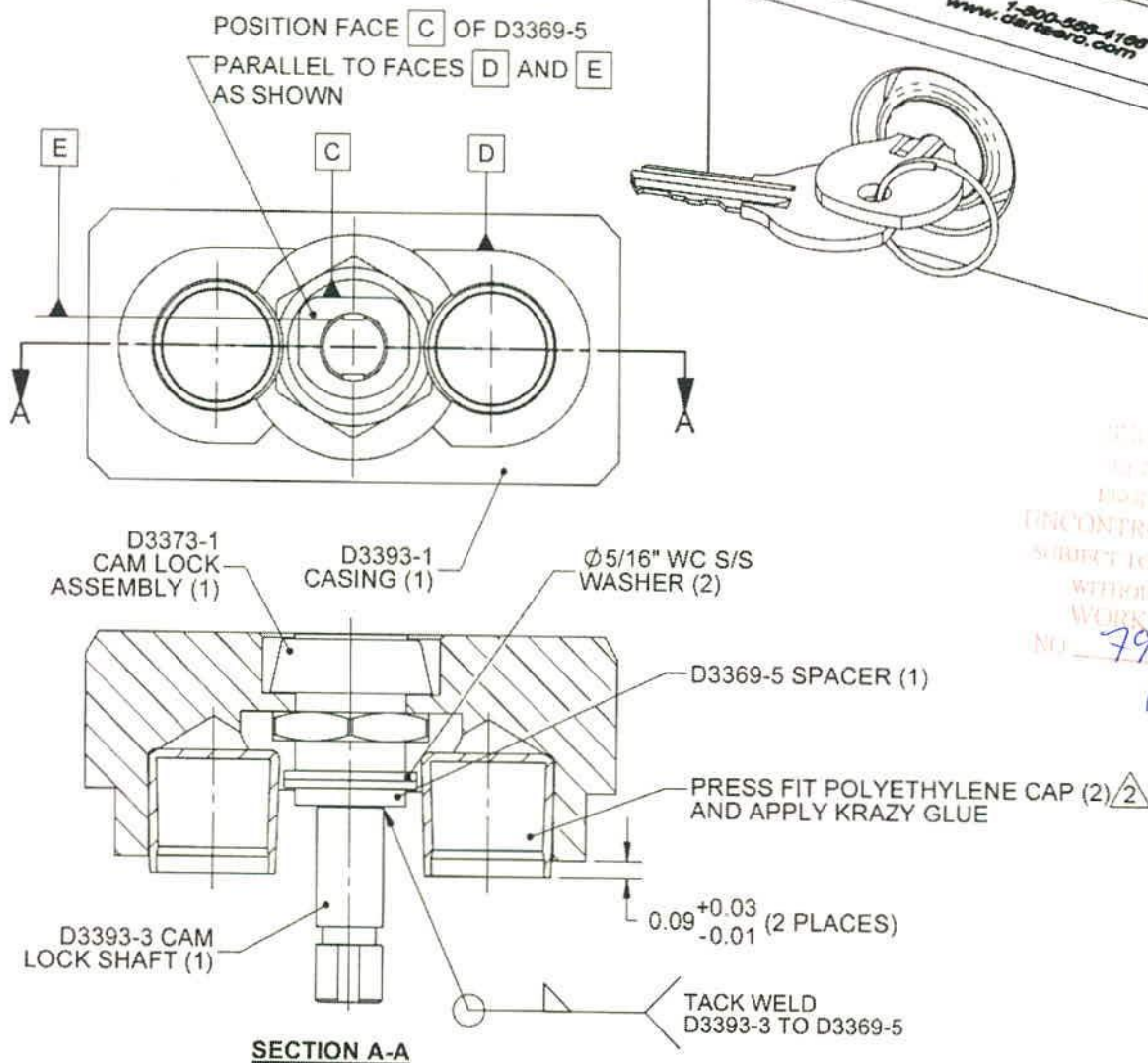
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**DART**

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3393</b>	REV. A SHEET 1 OF 3
DATE <b>05.02.08</b>		TITLE <b>BATTERY LOCK</b>	SCALE 1:1
A	05.02.08	NEW ISSUE	

**RELEASED**  
*[Signature]*  
05/03/09D2728-7  
LABEL (1)**BATTERY LOCK SHOWN  
LOCKED WITH KEY****D3393-041 BATTERY LOCK ASSEMBLY****NOTES:**

- 1) WELD PER DART QSI 004
- 2) POSSIBLE SUPPLIER: McMASTER-CARR, P/N 9567K21

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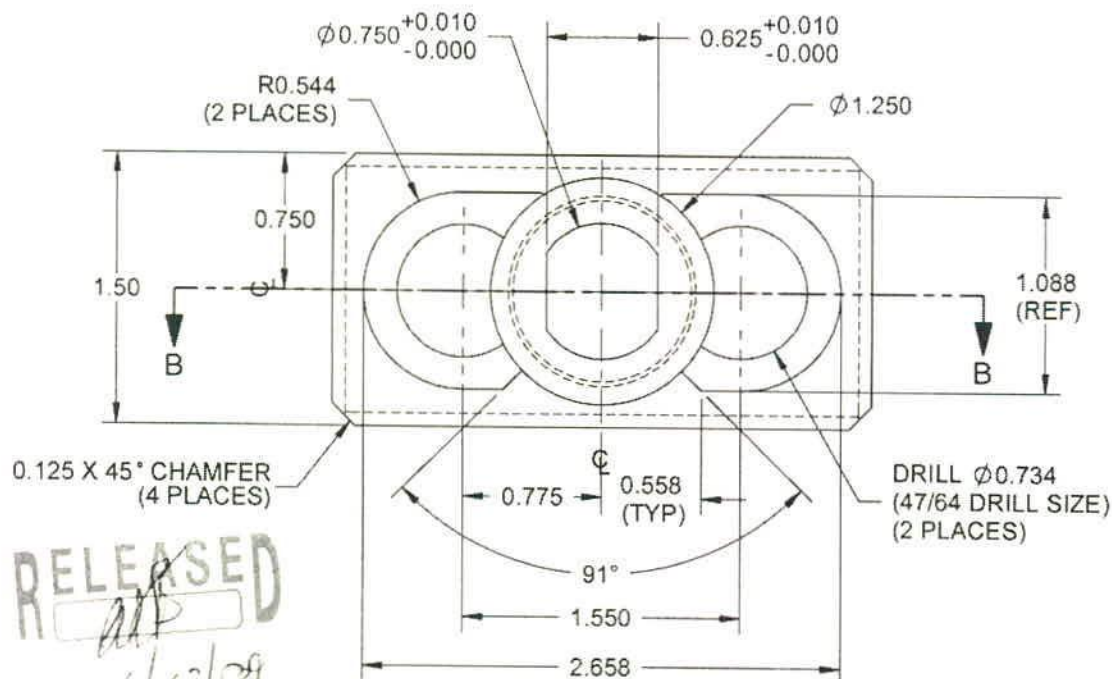
**NOTE:** Date & initial all entries



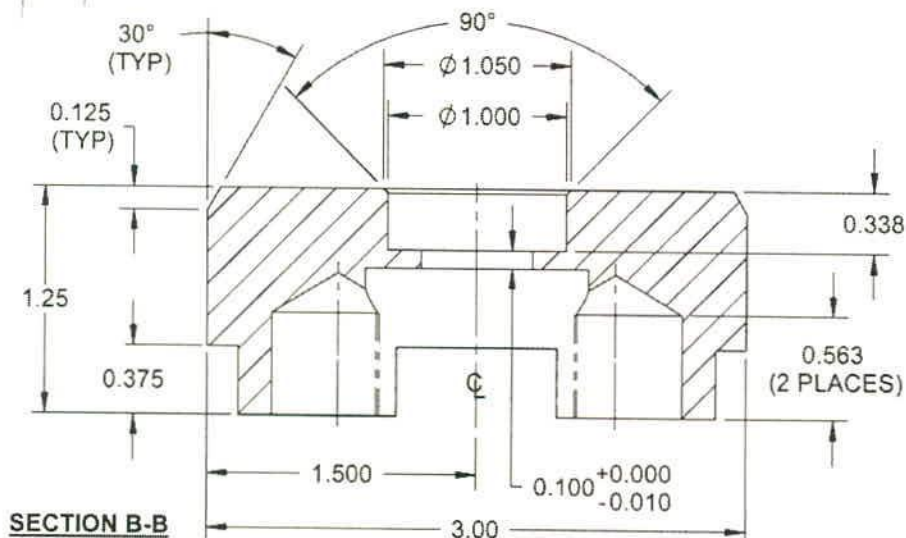
**DART**

79036

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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3393</b>	REV. A
DATE <b>05.02.09</b>		TITLE <b>BATTERY LOCK</b>	SHEET 2 OF 3
			SCALE 1:1



RELEASED  
*[Signature]*  
05/03/09



### D3393-1 CASING

#### NOTES:

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8)  
(REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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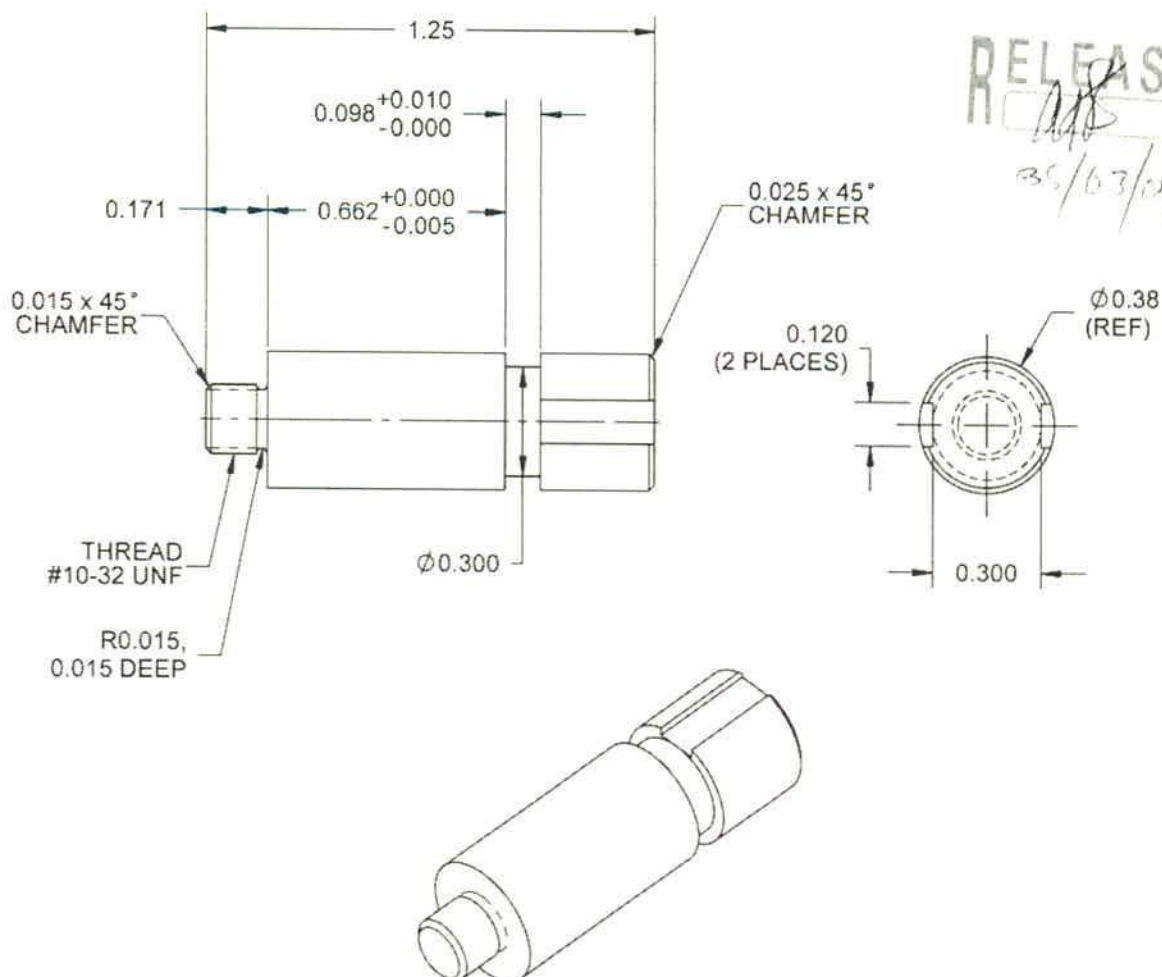
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**DART**

79036

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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3393	REV. A
DATE 05.02.09		TITLE BATTERY LOCK	SHEET 3 OF 3 SCALE 2:1



### D3393-3 CAM LOCK SHAFT

#### NOTES:

- 1) MATERIAL: AISI 303 S.S. (REF. DART SPEC. M303R0.375)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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